Section WFP 2-12 – Welding Fabrication Procedure

Attachment 1, Weld Reinforcement Table

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WELD REINFORCEMENT TABLE API 650

Thickness	Maximum Thickness of Reinforcement		
of Plate	Vertical Joints		Horizontal Joints
Up to ½ in.	$^{3}/_{32}$ in.		¹ / ₈ in.
Over ½ in. to 1 in.	¹ / ₈ in.		³ / ₁₆ in.
Over 1 in.	$^{3}/_{16}$ in.		1⁄4 in.
Sections to be Radiographed			
Thickness of Plate		Maximum Thickness of Reinforcement	
Up to ½ in.		$^{1}/_{16}$ in.	
Over ½ in. to 1 in.		³ / ₃₂ in.	
Over 1 in.		¹ / ₈ in.	